Work Order ID 133711

Tuesday, June 16, 2015 10:52:10 AM

133711

Item ID: PB67-43001-107 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Tube Arm

Start Date: 6/16/2015 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 6/16/2015 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Approvals: **Process Plan:** ML5 **Date:** JUN 17 2015 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**: B67-43001 / C									
100	Small Fab	0.00				6X		DA	15/6/30
100									
Small Fab	**Memo**	0.00							
Small Fab	1- cut to length as per dwg 2- deburr								
110	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89 JUL 10 2015
110						(6)			
QC	**Memo**	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: Mezz	0.00							JUL 14 2015
120			DAS 6 9-89			(6)JA			
Packaging	**Memo**	0.00							
Packaging									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
~~Suspected Unapproved~~ ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐
Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Date :	Step #:	QTY Effective :	MRB (QSI042) Approval

Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause

Environment ☐	☐ No Re-verfication	Design ☐	☐ Operator
Doc/Data ☐	☐ Offset/Setup	Equip/Tooling ☐	☐ Supplier
Handling/Pre ☐	☐ Training	Material ☐	☐ Use for Testing
Internal Transport ☐	☐ Poor Information	Tribal Knowledge ☐	☐ Rushing
LOA ☐	☐ Product Improvement	Substation ☐	☐ Process Improvement
Past Expiry Date ☐	☐ Manufacturing Process	Misidentified ☐	☐ Past Due

FAULT CATEGORY

☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong
☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions
☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect
☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved
☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing
☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish
☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

Item ID: PB67-43001-107 **Accept** *N900040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Tube Arm

Start Date: 6/16/2015 **Start Qty:** 6.00 *6*
Required Date: 6/16/2015 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1*
Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130						MLS			JUL 15 2015
QC	**Memo**	0.00							
Quality Control									

MLS JUL 15 2015

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No.

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Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
Large Fab ☐	Composite ☐	Supplier ☐	

Date :

Step #:

QTY Effective :

MRB (QSI042) Approval

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor Approval Verification

QC / QA Coordinator Approval

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Equip/Tooling ☐	☐	Supplier
Handling/Pre ☐	☐	Training
Material ☐	☐	Use for Testing
Internal Transport ☐	☐	Poor Information
Tribal Knowledge ☐	☐	Rushing
LOA ☐	☐	Product Improvement
Substation ☐	☐	Process Improvement
Past Expiry Date ☐	☐	Manufacturing Process
Misidentified ☐	☐	Past Due

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☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

Picklist Print

Tuesday, June 16, 2015 10:52:14 AM

Work Order ID: 133711

1333711

Parent Item: PB67-43001-107

PB67-43001-107

Parent Item Name: Tube Arm

Start Date: 6/16/2015 **Required Date:** 6/16/2015

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP Rev:A 08-06-26 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	10.1742	4	26			

M6061T6T1.000W065

6061T6 RD TUBE 1.00 x .065w

** DL 15/6/30

Location	Loc Qty	Loc Code	
GA002	10.17416		
M126183	1		
M130292	2.75846		
M131206	6.4157		

M132597

26

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

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Large Fab ☐	Composite ☐	Supplier ☐	

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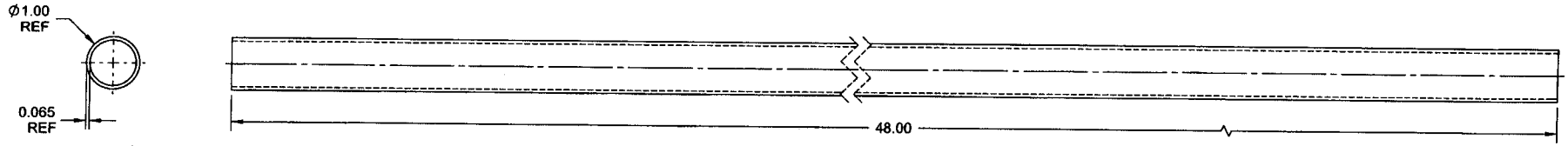
☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence

☐ OTHER :

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 133711 MJ
15-06-17



B67-43001-107 TUBE ARM

RELEASED
2009-09-24
MP

NOTES:
1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T0.500W.125
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 0.89 lbs

REV.	DESCRIPTION	BY	DATE
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISONS, REFER TO SHEET 32 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.	MB	09.02.26

DESIGN	RW	DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	AJS	DRAWING NO. B67-43001-107 REV. C
MFG. APPR.		SHEET 1 OF 1
APPROVED		TITLE TUBE ARM SCALE NTS
DE APPR.	N/A	
DATE	09.02.26	

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